

Work Order ID 59220

Friday, May 28, 2010 9:24:58 AM



Page 1

Item ID: D2565-105

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 5/27/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date:

10-5-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2565	Rev E								
100	NC BRAKE	0.00							
	Brake NC	0.00	<i>SB</i>	<i>10/06/07</i>					<i>(8)</i>
	Memo								
	Punch as per Dwg D2565 using DT 8313								
110	Small Fab	0.00							
	Small Fab	0.00							
	Memo								
	Drill hole open to .316 Ø as per Dwg D2565 (one end only) <input type="checkbox"/> Debur								<i>EB 10/06/07 (8)</i>
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00	<i>Selobor</i>						<i>(45)</i>
	Memo								
	Quality Control								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel M114841 Memo START TIME: 3:15pm 3:45pm FINISH TIME: 4:00pm OVEN TEMPERATURE: 400°F	0.00 0.00				8	0		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				8		BR 10-6-9	
150 Packaging Packaging	Identify as per dwg & Stock Location: 270 Memo	0.00 0.00				8	BB	10/06/09	

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/09 *[Signature]*
ms
10-6-9

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Picklist Print

Friday, May 28, 2010 9:25:04 AM

Page 1

Work Order ID: 59220



Parent Item: D2565-105



Parent Item Name: Strut

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP: F 02.04.16 Added dwg Rev.C1 NG

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	108.1489	1.6825	14.16842			



304 RD Tube .750 x .049W



Location	Loc Qty	Loc Code
MAT	80.2854	
108498	0	
114482	80.2854	
MAT017	27.8635	
109314	9.33	
110113	5.29	
112800	13.2435	

1114852

SB 10/6/07 ⑧
16

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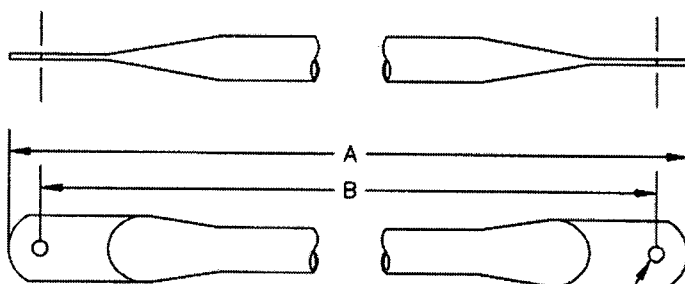


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59222

Handwritten signature



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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